



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2805-1

Job Sheet 200660



Part No: D2805-1

Job Qty: 12 pcs

Part Name: Stop



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/7/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV B IPP: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	10/7/19	10/7/19	0.00	0.58	Bandsaw - 1		DJP 19-10-21
110	HAAS 4 Axis - B4B	12 pcs	10/7/19	10/7/19	1.00	4.14	HAAS - 1 - B4B		DJP 19-10-21
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	12 pcs	10/7/19	10/7/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		



Container No: S224424



Part: D2805-1

Job No: 200660

Serial No/Batch: S224424

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/21/19

Plex 9/13/19 2:12 PM Dart.Renwick.Jennifer

					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	SBL 19/10/22
					QC 8 - 76	
					Handfinish - 1 - 1 - B4B	
140 Handfinish - 1-1 Chemical-B4B	12 pcs	10/7/19	0.00	0.35	Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	★ OCT 22 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 3	12 pcs	10/7/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	OCT 22 2019
					QC 3 - 9	
						DAS 68 9-89

Plex 9/13/19 2:12 PM Dart.Renwick.Jennifer

					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
160 Packaging 3-1 - Stock - B4B	12 ✓ pcs	10/7/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	BA116
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	12 ✓ pcs	10/7/19	0.00 0.00		QC 21 - SA - 21 ✓	BA116
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Bandsaw - Cut Bar: 3.150" Long +0.010/-0.030"

Descriptions: 110 - HAAS CNC Vertical Machine - 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Debur Identify as D2805-1

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock LOCATION : GA

170 - QC21- Final Inspection - Work Order Release

21

OCT 23 2019

 DAS
21
OCT 23 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X1.500	6061-T6 Bar 1.50 X 1.50	3,1500 ft (.2625 ea)	100-Bandsaw - 1	S017526

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X1.500	3	14	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stop	2.974Inches $\pm$ 0.010	2.984 2.964	2.978	
2	Stop	0.240Inches $\pm$ 0.010	0.250 0.230	0.2405	
3	Stop	0.100Inches $\pm$ 0.010	0.110 0.090	0.105	chamfer
4	Stop	1.420Inches $\pm$ 0.001	1.421 1.419	1.420	
5	Stop	1.125Inches $\pm$ 0.010	1.135 1.115	1.123	
6	Stop	0.250Inches $\pm$ 0.005 - 0.000	0.255 0.250	0.2505	
7	Stop	0.250Inches $\pm$ 0.010	0.260 0.240	0.248	
8	Stop	1.500Inches $\pm$ 0.010	1.510 1.490	1.496	
9	Stop	1.000Inches $\pm$ 0.010	1.010 0.990	0.998	
10	Stop	0.875Inches $\pm$ 0.001 - 0.000	0.876 0.875	0.875	
11	Stop	0.191Inches $\pm$ 0.005 - 0.000	0.196 0.191	0.191	Diameter
12	Stop	2.689Inches $\pm$ 0.010	2.699 2.679	2.688	

S017526 (IN Rack)

Plex 9/13/19 2:12 PM Dart.Renwick.Jennifer

Start = 62.750" (5,229 ft)
 End = 24.125" (2,010 ft)
 Used $\Rightarrow$ 38,625" (3,219 ft)

DAS
73
9-89

19-10-21

Used $\rightarrow$ 3,219 ft.BOM $\rightarrow$ 3,150 ft.Scrap $\rightarrow$ 0,069 ft

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ ☐											
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042) _____											
Description Work Order Deviation						Disposition											
Completed By						Lead hand / Supervisor											
												QC / QA Coordinator					
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐						FAULT CATEGORY Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ Other/Details: _____						Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐					